

Date: Tuesday, 6/13/2006 10:04:25 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPRING
 Job Number : 27366
 Estimate Number : 10862
 P.O. Number :
 This Issue : 6/13/2006 S.O. No. :
 Prsht Rev. : NC Part Number : D31131
 First Issue : 6/5/2006 Type : PURCHASED PARTS Drawing Number : D3113 REV B
 Drawing Revision : B
 Previous Run :
 Material :
 Due Date : 6/30/2006 Qty: 4 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By :
 Comment : Est. A 02.05.16 New Issue NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

2.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0500 sf(s)/Unit Total: 0.2000 sf(s)
 Spring

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0 ~~QES~~ DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK
 Check dims to dwg
 Deburr sharp edge 0.005 to 0.010

SAP 062000.13

(4)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: st 408

6/4/14 6

See WIP
 Attached

Date: Tuesday, 6/13/2006 10:04:25 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 27366

Part Number: D31131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 26-06/4

Date: Monday, 6/5/2006 7:47:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPRING
 Job Number : 27366
 Estimate Number : 10862
 P.O. Number :
 This Issue : 6/5/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : PURCHASED PARTS
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est. A 02.05.16 New Issue NG

Part Number : D31131
 Drawing Number : D3113 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 6/30/2006 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

Make as per dwg D3113

Possible Supplier: Industrial Laser cutting
(replaces Bell p/n 205-030-803-001)

Material release note required

M304S16 GA 0.063" thick
 M7106
 batch: ~~M7106~~ (0.050 Sqft)
 MM 06 06 07

2.0

D3113TF

Water Jet

Spring



Prog rev. B
 Dwg rev. B



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring

MM 06 06 07 (4)

3.0

PACKAGING 1

QC2

PACKAGING RESOURCE #1



MM 06 06 08 (4)



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC2

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Check dims to dwg

Deburr sharp edge 0.005 to 0.010

Ja-06-12 (4)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

2408

06/06/14 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-06-12	4.1	Debaring after QC 8. Make a step with barcode Permanent change.					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:47:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 27366

Part Number: D31131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

 06/06/14 

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

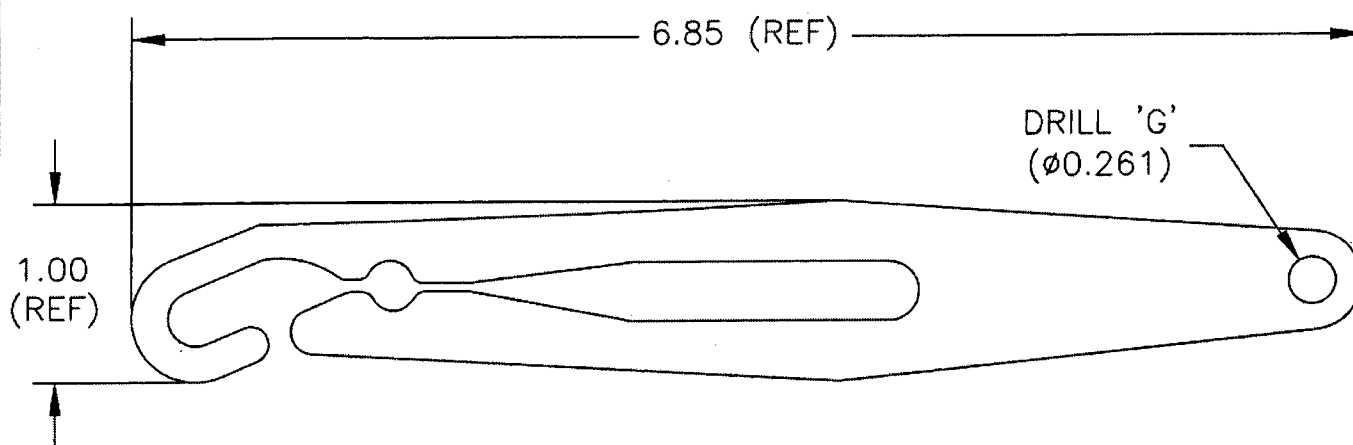
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN A	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3113	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE SPRING	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; ADDED ANNEALED	

RELEASED
04.11.23**D3113-1 SPRING****NOTES:**

- 1) MACHINE PER DWG FILE "D3113-B1.DWG"
- 2) MATERIAL: ANNEALED 16 GAUGE (0.063" REF) AISI 304/316 SS SHEET PER MIL-S-5019 (REF DART SPEC M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27366

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